

Date: Thursday, 22/11/2007 9:04:46 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING ANGLE  
 Job Number : 35959  
 Estimate Number : 10509  
 P.O. Number : N/A Part Number : D2564  
 This Issue : 22/11/2007 S.O. No. : N/A Drawing Number : D2564 REV. B1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B1  
 Previous Run : 34933 Material : N/A  
 Due Date : 29/11/2007 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est:D 02.09.09 Re-format; Added FA276 Folio KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6207 Angle Extrusion 1x1x.125



Comment: Qty.: 0.0962 f(s)/Unit Total: 0.3847 f(s)

Angle Extrusion

Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)

(D6207)

Batch: 327538

401-11-22 4

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

401-11-22 4

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA276 and Dwg D2564

Tumble and Deburr

Identify as D2564

Small FAB.  
(this time only)

401-11-22 4

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

401-11-22 4

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

401-11-22 (24)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: RP Date: 07/11/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 22/11/2007 9:04:46 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 35959

Part Number: D2564

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

WA

U

07-11-22

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

4  
EZ0711100

Job Completion



U 07-11-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

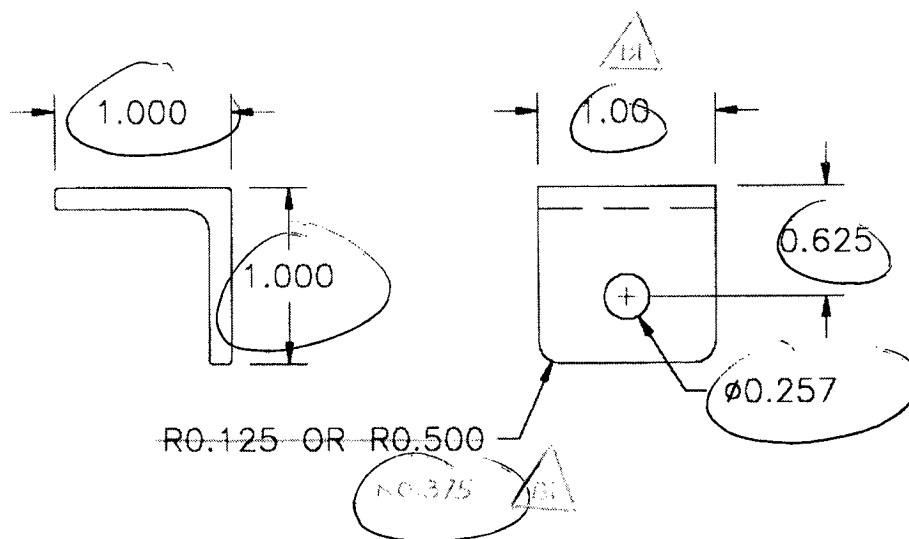
NOTE: Date & initial all entries

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	MIKE M	DRAWING NO.	REV. B
CHECKED	APPROVED	D2564	SHEET 1 OF 1
BW	BW		
DATE	TITLE		SCALE
96:04:30	MOUNTING ANGLE		1:1
B	97:05:06	MODIFIED DIMENSIONS	
DI	4-11-97	R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.500	

RELEASED  
97/05/06 BW



NOTES

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125  
MAKE FROM DOLL/HAXX ANGLE EXTRUDED
- 2) BREAK ALL SHARP EDGES PER DART
- 3) TOLERANCES PER DART SPECIFICATION UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

W/LO 35959

